

Work Order ID 81572

March-15-12 1:01:03 PM

81572

Page 1

Item ID: D350-607-143

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Automatic Lid Opener Installation

Stop ***NS2***

Start Date: 15/03/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 13/04/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/03/15

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D350-607-1	A

100 0.00

100

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D350-607-143
CHG001

N/A

110 Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

2x

Sp 12-04-16

120 QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

*use Assembly on
Baskets 5/26/17*

*Do Not package - will be assembled on D350-607-077A
81563/81564*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 81572

March-15-12 1:01:03 PM

81572

Page 2

Item ID: D350-607-143

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Automatic Lid Opener Installation

Start Date: 15/03/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 13/04/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00

130

Packaging

Memo

Identify and pack for shipping as per PPP D350-607-143

Location: _____

PPP rev: _____

0.00

Packaging

140

0.00

140

QC

QC21- Final Inspection - Work Order Release

Memo

0.00

Quality Control

12/4/17

MF
12-04-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March-15-12 1:01:07 PM

Page 1

Work Order ID: 81572

81572

Parent Item: D350-607-143

D350-607-143

Parent Item Name: Automatic Lid Opener Installation

Start Date: 15/03/2012

Required Date: 13/04/2012

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP RevA: New issue DD verified by:EC
per dwg revC DD 10.01.18 verified by:EC
545 DD 10.04.19 verified by:EC

IPP RevB: as
IPP Rev:C as per ecn10-

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3953-7 *D3953-7* Spring Spacer		Manufactured	No			110	Each	12.0000	1	2			
--	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

**

B82045 SP

Location

Loc Qty

Loc Code

ST075

12

76295

12

D3953-3 *D3953-3* Gas Spring Stud, Lid		Manufactured	No			110	Each	24.0000	1	2			
---	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

**

SP B82044

Location

Loc Qty

Loc Code

ST075

24

76659

4

78042

20

D3953-5 *D3953-5* Gas Spring Stud, Base		Manufactured	No			110	Each	11.0000	1	2			
--	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

**

SP

Location

Loc Qty

Loc Code

ST075

11

77506

11

D3953-9 *D3953-9* Gas Spring Washer		Manufactured	No			110	Each	16.0000	2	4			
--	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

**

B82035

SP Double

Location

Loc Qty

Loc Code

ST075

16

78916

16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March-15-12 1:01:07 PM

Page 2

Work Order ID: 81572

81572

Parent Item: D350-607-143

D350-607-143

Parent Item Name: Automatic Lid Opener Installation

Start Date: 15/03/2012

Required Date: 13/04/2012

Start Qty: 2.00

Required Qty: 2.00

D3953-11 Manufactured No

110 Each 14.0000 1 2

D3953-11

Gas Spring Spacer

**

SP

Location

Loc Qty

Loc Code

ST075

14

71268

2

79338

12

2x/18
1x

D3953-15 Manufactured No

110 Each 24.0000 1 2

D3953-15

Gas Spring Bracket

**

SP

Location

Loc Qty

Loc Code

ST075

24

71269

3

79337

21

2x

D3953-17 Manufactured No

110 Each 5.0000 1 2

D3953-17

Gas Spring Spacer

**

BS/206 SP

Location

Loc Qty

Loc Code

ST075

5

76294

5

D3969-1 Manufactured No

110 Each 14.0000 1 2

D3969-1

Spring (Basket Lid)

**

SP 12-04-16

Location

Loc Qty

Loc Code

ST272

14

73523

14

2x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March-15-12 1:01:07 PM

Page 3

Work Order ID: 81572

81572

Parent Item: D350-607-143

D350-607-143

Parent Item Name: Automatic Lid Opener Installation

Start Date: 15/03/2012

Required Date: 13/04/2012

Start Qty: 2.00

Required Qty: 2.00

AN3C11A Purchased No

110 Each 58.0000 2 4

AN3C11A

BOLT

**

SP

Location

Loc Qty

Loc Code

ST351

58

118838

8

119798

50

4x

AN3C15A Purchased No

110 Each 47.0000 2 4

AN3C15A

Bolt

**

SP

Location

Loc Qty

Loc Code

ST352

47

119973

47

4x

AN310-4 Purchased No

110 Each 72.0000 2 4

AN310-4

NUT

**

SP 12-04-16.

Location

Loc Qty

Loc Code

ST344

72

120124

22

120518

25

121011

25

4x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March-15-12 1:01:07 PM

Page 4

Work Order ID: 81572

81572

Parent Item: D350-607-143

D350-607-143

Parent Item Name: Automatic Lid Opener Installation

Start Date: 15/03/2012

Required Date: 13/04/2012

Start Qty: 2.00

Required Qty: 2.00

MS21043-3

Purchased

No

110

Each

818.0000

4

MS21043-3

Nut

**

⑧
m121255 SP

Location

Loc Qty

Loc Code

FG

72

103691

72

GA

316

120693

316

ST301

430

118077

2

118614

378

118686

30

119758

20

MS24665-2-12

Purchased

No

110

Each

148.0000

2

4

MS24665-2-12

COTTER PIN

**

SP.

Location

Loc Qty

Loc Code

ST309

148

118078

148

NAS1149C0332R

Purchased

No

110

Each

3,541.000

4

8

NAS1149C0332R

Washer

**

4x
m121255
SP 12-04-16.

Location

Loc Qty

Loc Code

ST297

3541

118354

515

119736

196

120648

2830

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March-15-12 1:01:07 PM

Page 5

Work Order ID: 81572

81572

Parent Item: D350-607-143

D350-607-143

Parent Item Name: Automatic Lid Opener Installation

Start Date: 15/03/2012

Required Date: 13/04/2012

Start Qty: 2.00

Required Qty: 2.00

NAS1149C0432R

Purchased

No

110

Each

2,562.000

2

4

NAS1149C0432R

SP 12-04-16

Washer

Location

Loc Qty

Loc Code

ST297

2562

117291

1562

119124

1000

4.

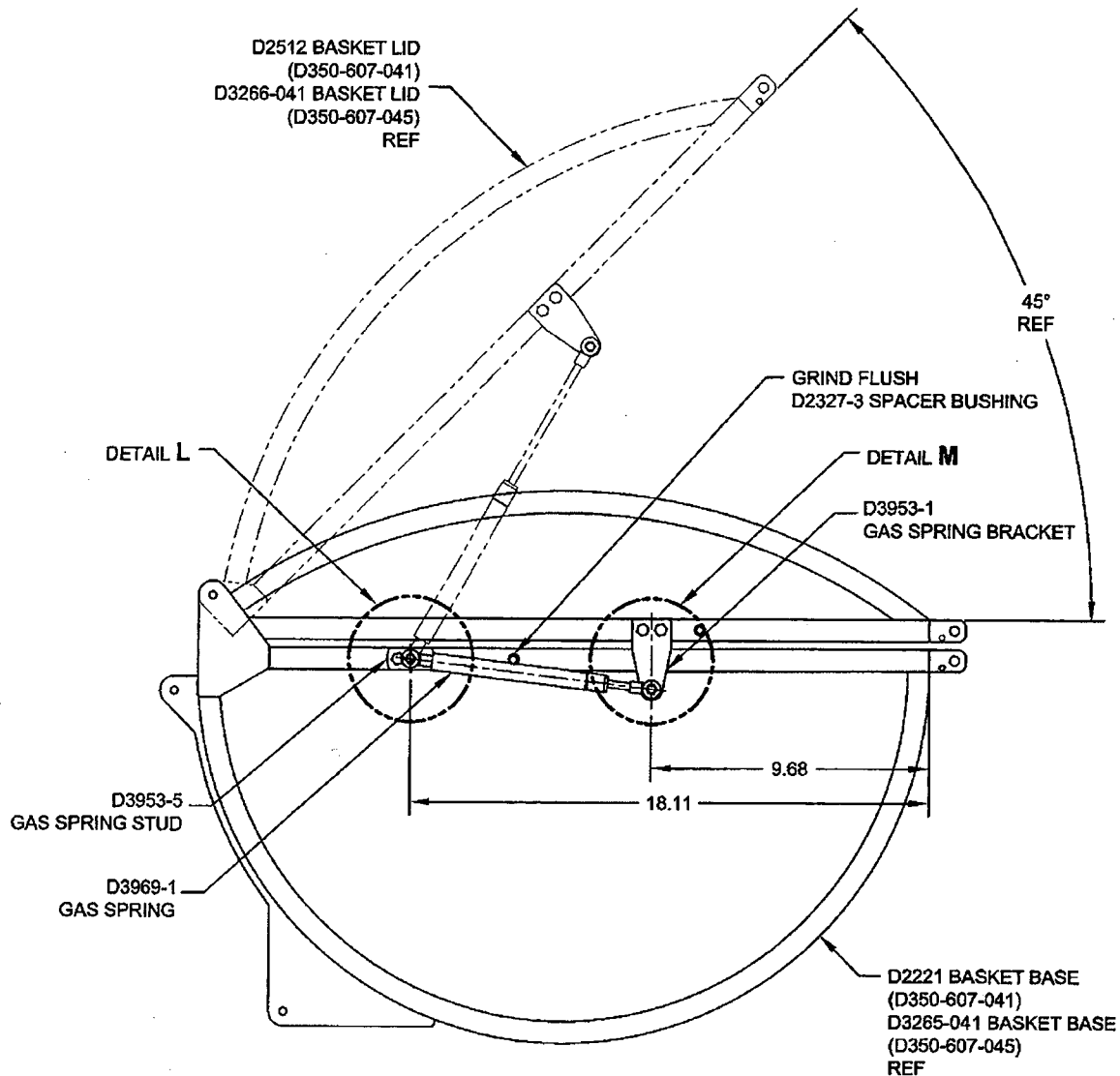
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D350-607-141 AUTOMATIC LID OPENER INSTALLATION
(BOTH ENDS)

D350-607-145 AUTOMATIC LID OPENER INSTALLATION
(1 END ONLY)

Figure 8a – Automatic Lid Opener Installation

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 01522446

• COPYRIGHT © 1994 BY DART AEROSPACE LTD. •
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Revision: **A**
Date: 10.03.10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries